

Amendments to the Claims

This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

1-17. (Canceled)

18. (Previously Presented) A method of making a vehicle component, the method comprising:

providing a first mold section, a second mold section, a first projection extending from the first mold section toward the second mold section, and a first shut-off member opposite the first projection and movable between a first position and a second position;

providing a first cavity defined by a first portion of the first mold section, the first projection, a first portion of the second mold section, and the first shut-off member when in the first position;

positioning a formed skin in the first cavity proximate the first mold section so that a first edge of the formed skin extends outward past the first projection toward the second mold section such that a free end of the first edge faces the first shut-off member;

injecting a first resin into the first cavity and bonding to the formed skin;

moving the first shut-off member from the first position to the second position to provide a second cavity defined by a second portion of the first mold section, a second portion of the second mold section, the first edge of the formed skin that is extended past the first projection, the first resin, and the first shut-off member when in the second position;

injecting a second resin into the second cavity while the first edge of the formed skin remains extended past the first projection and bonding the second resin to the first resin and the first edge of the formed skin.

19. (Previously Presented) The method of Claim 18 wherein the first shut-off member comprises a recess to receive the first edge of the formed skin.

20. (Previously Presented) The method of Claim 18 further comprising:
providing a second projection extending from the first mold section;
wherein the step of positioning the formed skin in the first cavity comprises
positioning the formed skin in the first cavity proximate the first mold section so that a first edge
of the formed skin extends past the first projection and so that a second edge of the formed skin
extends past the second projection;

wherein the step of injecting the first resin into the first cavity comprises injecting
the first resin between the formed skin and the first portion of the second mold section and
between the first portion of the first mold section and the first portion of the second mold section
so that an outer surface of the vehicle component is provided by the formed skin and by the first
resin.

21. (Previously Presented) The method of Claim 20 further comprising:
providing a third projection extending from the first mold section and a second
shut-off member opposite the third projection and movable between a first position and a second
position

moving the second shut-off member from the first position to the second position
to provide a third cavity defined by the third projection, a third portion of the first mold section, a
third portion of the second mold section, a portion of the first resin disposed directly between the
first mold section and the second mold section, and the second shut-off member when in the
second position;

injecting a third resin into the third cavity and bonding to the first resin.

22. (Previously Presented) The method of Claim 18 wherein the formed skin
comprises a flexible sheet and a compressible material coupled to at least a portion of the flexible
sheet.

23. (Previously Presented) The method of Claim 18 wherein the formed skin comprises a flexible sheet and a compressible material coupled to a portion of the flexible sheet, and wherein the step of injecting the first resin into the first cavity and bonding to the formed skin comprises injecting the first resin into the first cavity and bonding to the flexible sheet and to the compressible material to provide a first compressible region where the first resin is bonded directly to the skin and a second compressible region where the first resin is bonded directly to the compressible material.

24. (Previously Presented) The method of Claim 18 wherein the first resin is at least partially solidified when the second resin is injected.

25. (Previously Presented) The method of Claim 18 wherein the formed skin is positioned in an area of the vehicle component that may be interfaced by a user.

26. (Previously Presented) The method of Claim 18 wherein the formed skin partially provides an “A” surface of the vehicle component.

27. (Previously Presented) The method of Claim 18 wherein the vehicle component is one of a vehicle door panel or a vehicle instrument panel.

28. (Previously Presented) A method of making a vehicle component, the method comprising:

providing a first mold section, a second mold section, a first projection extending from the first mold section, a second projection extending from the first mold section, and a shut-off member opposite the first projection and movable between a first position and a second position;

providing a first cavity defined by the first projection, a first portion of the first mold section, a first portion of the second mold section, the second projection, and the first shut-off member when in the first position;

providing a formed skin having a first edge and a second edge;

positioning the formed skin in the first cavity proximate the first mold section between the first projection and the second projection so that the first edge of the formed skin extends outward past the first projection toward the second mold section such that a free end of the first edge faces the first shut-off member;

injecting a first resin into the first cavity and between the formed skin and a first portion of the second mold section and between a first portion of the first mold section and the first portion of the second mold section so that an outer surface of the vehicle component is provided by the formed skin and by the first resin;

moving the first shut-off member from the first position to the second position to provide a second cavity defined by a second portion of the first mold section, a second portion of the second mold section, the first edge of the formed skin that is extended past the first projection, the first resin, and the first shut-off member when in the second position;

injecting a second resin into the second cavity while the first edge of the skin remains extended past the first projection and bonding the second resin to the first resin and the first edge of the formed skin.

29. (Previously Presented) The method of Claim 28 wherein the step of positioning the formed skin the first cavity provides that the second edge of the formed skin extends past the second projection

30. (Previously Presented) The method of Claim 28 wherein the first resin comprises a first polymeric material and the second resin comprises a second polymeric material different than the first polymeric material.

31. (Previously Presented) The method of Claim 30 wherein the first resin comprises a first color and the second resin comprises a second color different than the first color.

32. (Previously Presented) The method of Claim 30 wherein the first polymeric material comprises a first color and the second polymeric material comprises a second color which is approximately the same as the first color.

33. (Previously Presented) The method of Claim 28 wherein the first resin comprises a first polymeric material and the second resin comprises a second polymeric material which is the same as the first polymeric material.

34. (Previously Presented) The method of Claim 33 wherein the first polymeric material comprises a first color and the second polymeric material comprises a second color different than the first color.

35. (Previously Presented) A method of making a vehicle component, the method comprising:

providing a first mold section, a second mold section, a first projection extending from the first mold section, a second projection extending from the first mold section, a third projection extending from the first mold section, a first shut-off member opposite the first projection and movable between a first position and a second position, and a second shut-off member opposite the third projection and movable between a first position and a second position;

providing a first cavity defined by the first projection, a first portion of the first mold section, a first portion of the second mold section, the second projection, the first shut-off member when in the first position, and the second shut-off member when in the first position;

providing a formed skin having a first edge and a second edge;

positioning the formed skin in the first cavity proximate the first mold section between the first projection and the second projection so that the first edge of the formed skin extends outward past the first projection toward the second mold section such that a free end of the first edge faces the first shut-off member and so that the second edge of the formed skin extends past the second projection;

injecting a first resin into the first cavity and between the formed skin and a first portion of the second mold section and between a first portion of the first mold section and the first portion of the second mold section so that an outer surface of the vehicle component is provided by the formed skin and by the first resin;

moving the first shut-off member from the first position to the second position to provide a second cavity defined by a second portion of the first mold section, a second portion of

the second mold section, the first edge of the formed skin that is extended past the first projection, the first resin, and the first shut-off member when in the second position;

injecting a second resin into the second cavity while the first edge of the formed skin remains extended past the first projection and bonding the second resin to the first resin and the first edge of the formed skin;

moving the second shut-off member from the first position to the second position to provide a third cavity defined by a third portion of the first mold section, a third portion of the second mold section, a portion of the first resin disposed between the first mold section and the second mold section, and the second shut-off member when in the second position;

injecting a third resin into the third cavity so that a portion of the third resin bonds to the first resin.

36. (Previously Presented) The method of Claim 35 wherein the first shut-off member comprises a recess to receive the first edge of the formed skin.

37. (Previously Presented) The method of Claim 35 wherein the second shut-off member comprises a forward surface, a first side surface, a second side surface that shares an edge with the forward surface, and an angled surface that extends between the forward surface and the first side surface; and wherein the step of injecting a third resin comprises forming an angled recess in the molded article having an upper surface provided by the angled surface of the second shut-off member and provided at a sufficiently flat angle relative to vertical by the angled surface of the shut-off member to obscure the interface between the first resin and the third resin from an occupant of the vehicle interior.